Rush Ship Tomorrow

Work Order ID 107827 *107827*

October-03-13 11:28:37 AM

Item ID: D2810-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 10/03/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 10/17/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** MLS **Date:** 13-10-03 **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2810	**Revision Nbr** Rev C								
100 *100* Brake NC / Brake NC	NC BRAKE	0.00				10	SAO	13-10-30	
	Memo 1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr	0.00							
110 *110* QC / Quality Control	QC5- Inspect part completeness to step on W/O	0.00	DAS 16 9-89 13-10-30			(NO)			
	Memo	0.00							
120 *120* Powdercoat / Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M117338.	0.00				10	∅	13-10-30.	DAS 34 9-89
	Memo START TIME: 1:05 OVEN TEMPERATURE: 320° FINISH TIME: 1:35	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	____________	

Work Order ID 107827

October-03-13 11:28:37 AM

107827

Item ID: D2810-5 **Accept** *N900040100* **Setup** **Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 10/03/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 10/17/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run** **Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00 DAS 27 9-89 13.10.30				10			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST253 (3x0) Memo (7X)PPP 107825	0.00 0.00				10x	DAS 28 9-89	13-10-30	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					13/10/31		

13.10.31

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-13 11:28:41 AM

Work Order ID: 107827

107827

Parent Item: D2810-5

D2810-5

Parent Item Name: Strut

Start Date: 10/03/13 **Required Date:** 10/17/13

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP A04.11.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	725.3652	1.9175	21			
M304TR0 500W 035									**		SAD	13-10-30	
304 RD Tube .500 x .035W													

Location		Loc Qty	Loc Code	
MAT017		725.3651825		
	118702	0.00003		
	123303	138.9645		
	125513	286.400653		
	m126922	300		21

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
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	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Operator ☐									
Material ☐									
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Process ☐									
Supplier ☐									
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FAULT CATEGORY

Landing Gear	**General**			
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☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

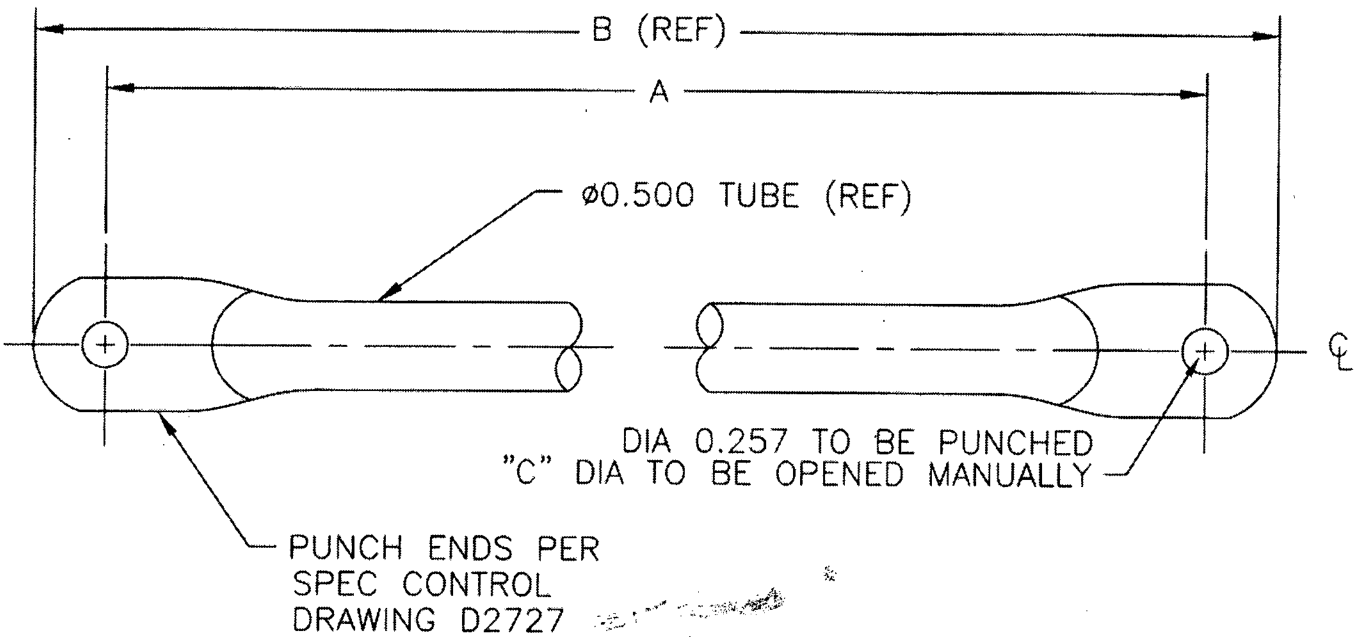
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS

A	00.11.08	NEW ISSUE
B	03.09.11	ADD FINISH
C	04.11.22	ADD −5

RELEASED 05.03.11



PART #	A	B	C
D2810−1	25.33	26.13	N/A
D2810−3	24.60	25.40	N/A
D2810−5	23.01	23.81	0.266

D2810−1/−3/−5

1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.500 x 0.035 WALL (M304TR0.500W.035)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD

Description:	Strut	Work Order:	107827
Inspection Drawing:	D2810-5	Rev: C	Part Number: D2810-5

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.01	+/- 0.030	23.01	✓		M-T	SAD-1
23.81	+/- 0.030	23.80	✓		M-T	SAD-1
0.266	+/- 0.006 / 0.001	0.266	✓		Vern	SFab-08

Measured by: SAD	Checked By: DAS 30 9-89	QC inspector: DAS 16 9-89	Engineering Approval (*if necessary*):
Date 13-10-30	Date 13/10/30	Date 13/10/30	Date N/A